

Work Order ID 133478

133478

Page 1

Monday, June 08, 2015 4:11:59 PM

Item ID: D350-836-019

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 6/11/15 Start Qty: 1.00 **

Cust Item ID:

Required Date: 6/11/15 Req'd Qty: 1.00 **

Customer:

Reference:

Approvals: Process Plan: MCS Date: JUN 09 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-1	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D350-836-019 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS 1506-11

DAS 6 9-89 / DAS 02 9-89

JUN 11 2015

DAS 27 9-89 / JUN 11 2015 DAS 26 9-89

DAS 6 9-89 / DAS 02 9-89

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

Work Order ID 133478***133478***

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Monday, June 08, 2015 4:11:59 PM

Item ID: D350-836-019

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 6/11/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/11/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-836-019

Location: _____

PPP Rev: _____

Ship

JUN 11 2015

DAS

6

8-89 /

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ

JUN 11 2015

MCJ

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

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Work Order ID: 133478

133478

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 6/11/15

Required Date: 6/11/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-1 *D4853-1* Top Bracket (Replaces P/N G13013-1) DAS 02 9-89		Manufactured	No				Each	9.0000	**	1	DAS 27 9-89		DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST519				9					
				126142				9					
D4854-1 *D4854-1* Lower Bracket (Replaces P/N G13013-2) DAS 02 9-89		Manufactured	No				Each	18.0000	**	1	DAS 27 9-89		DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				st526				18					
				109079				3					
				126502				15					
D4855-1 *D4855-1* Antenna Bracket (Replaces P/N G13013-3) DAS 02 9-89		Manufactured	No				Each	18.0000	**	1	DAS 27 9-89		DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				st526				18					
				109084				2					
				126143				10					
				128258				6					

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Work Order ID: 133478

133478

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 6/11/15

Required Date: 6/11/15

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each

214.0000

2

D2732-030

DAS
27
9-89

DAS
26
9-89

Rubber Cushion - 3"

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

88

107346

2

117118

22

124849

60

132003

4

ST410

126

133074

126

2

AN4-16A

Purchased

No

Each

242.0000

2

AN4-16A

DAS
27
9-89

DAS
26
9-89

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST325A

186

M132317

186

ST343

51

M128813

4

M132035

47

AN4-11A

Purchased

No

Each

229.0000

2

AN4-11A

DAS
27
9-89

DAS
26
9-89

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST325A

209

11921

1

M128362

207

M128769

1

JUN 11 2015

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133478

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 6/11/15

Required Date: 6/11/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

Each

836.0000

8

NAS1149D0432.J

WASHER

DAS

02

9-89

Location

Loc Qty

Loc Code

ST269

836

m131026

836

Each

5,121.000

4

MS21042L4

Purchased

No

MS21042L4

Locknut

DAS

02

9-89

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

208

m127813

208

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

825

m128300

8

m130388

7

m130922

97

m131618

12

m132123

701

DAS 26 9-89

DAS

27

9-89

DAS

27

9-89

DAS

26

9-89

JUN 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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5. PARTS LIST

Qty -019	Qty -111	Part Number	Description
X		D350-836-019	CROSSTUBE ANTENNA MOUNT KIT AS350/355 (P162-350)
	X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
	1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
	1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
	1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
	1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	AN4-16A	BOLT
2	2	AN4-11A	BOLT
8	8	NAS1149D0432J	WASHER
4	4	MS21042L4	LOCKNUT